

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000127**Date Inspected:** 08-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**Witness:** **Procedure Qualification Record**  
**Welding** **NDT**

**Welder Qualification** **Fracture Critical**  
**Mechanical Testing, describe:**

**Index Lot #:** B49-005-07**Witness Lot #:****Bridge No:** 34-0006**Component:** Bid: 52, 55 Tower & Girder**Welder:** Jiang Xiao Hu**ID #:** NA**Joint Description:** T-Joint

N/A

**WPS ID #:** PWPS-B-T-2133-1

N/A

**Base Metal:** A709-50F-2

N/A

**PQR ID #:** HP200715

N/A

**Thickness:** 26 mm

N/A

**Process:** FCAW

N/A

**Electrode Spec/Class:** AWS A5.20/E71T1-1

N/A

**Positions:** 3F min. multi pass weld

N/A

**Backing Material:** NA

N/A

**CWI:** Liu Liu

N/A

**Average Amps:** 197.5

N/A

**AWS Code:** D1.5

N/A

**Average Volts:** 25.5

N/A

**Applicable Sec:** 5.10.3

N/A

**Travel Speed:** 122.5

N/A

**Heat Input:** 2.4 kJ/min

N/A

**Preheat:** 65 degrees Celsius

N/A

**Summary of Items Observed:**

Summary Items Observed: Caltrans Quality Assurance (QA) Inspector was present as requested to witness the welding of a procedure qualification (PQR) test plate using flux core arc welding (FCAW) semi-automatic welding process. The welding was performed in accordance with AWS D1.5 2002, Section 5.10.3 fillet weld soundness requirements. The welding appeared to comply with the contract documents. The completed weld test was visually inspected by ZPMC Quality Assurance Inspector, Mr. Liu Liu and accepted for conformance to AWS requirements.

**Summary of Conversations:**

As identified within the contents of this report.

**Observed welding,testing or results:**

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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## WELDING WITNESS REPORT

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<b>Inspected By:</b>	Hasler,Mike	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClary,David	QA Reviewer
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